

CLAIMS

1. A method of assembling steering columns,
comprising the steps of:

5 forming a cylindrical column jacket;
 forming a pair of joint projections
 comprising inner surfaces in a circular arc shape
 conforming to an outer surface of said column
 jacket on a bracket;

10 temporary fitting said projections of said
 bracket along the outer surface of said column
 jacket; and

 crimping said projections into the outer
 surface of said column jacket.

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2. A method of assembling steering columns,
comprising the steps of:

 forming a cylindrical column jacket;

20 forming a pair of flat surfaces back to back
 on an outer surface of said cylindrical column
 jacket;

 forming a pair of joint projections
 comprising flat inner surfaces conforming to the
 pair of flat surfaces of said column jacket on a
25 bracket;

 temporary fitting said projections of said
 bracket along the flat surface of said column
 jacket; and

crimping said projections into the flat
surface of said column

3. A method of assembling steering columns
5 according to claim 1 or claim 2, wherein in
forming said a pair of joint projections, said
projections are symmetrically formed with respect
to the center of said bracket.

10 4. A method of assembling steering columns
according to claim 1 or claim 2, wherein in
crimping said projections, these are crimped with
a punch which is pressed toward the center of said
column jacket.

15 5. A method of assembling steering columns
according to claim 1 or claim 2, wherein in
forming said column jacket, a cylindrical column
jacket is formed from a mild steel tube.

20 6. A method of assembling steering columns
according to claim 1 or claim 2, wherein in
forming said column jacket, a cylindrical column
jacket is formed from an Al-Mn alloy tube.